

Date: Wednesday, 3/7/2007 2:22:36 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: SPACEPOD DOOR LH		
Job Number	: 31046C			Part Number	: D31861		
Estimate Number	: 11095			Drawing Number	: D3186		
P.O. Number	:			Project Number	: N/A		
This Issue	: 3/7/2007	S.O. No.	:	Drawing Revision	: C		
Prsht Rev.	: NC			Material	: N/A		
First Issue	: 3/7/2007	Type	: SMALL /MED FAB	Due Date	: 3/30/2007		
Previous Run	: 30623B			Qty:	1	Um:	Each
Written By	:						
Checked & Approved By	:						
Comment	: Est Rev:A New Issue 05-11-29 JLM						

Additional Product

Job Number:						
Seq. #:	Machine Or Operation:	Description :				
1.0	31046C01 	30076	SPACEPOD DOOR LH 			
Comment: Sub-Component SPACEPOD DOOR LH ml07/08/07						
2.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1 			(Pto → X1)	
Comment: SMALL & MEDIUM FAB RESOURCE 1 ml07/08/07						
1-Drill holes and cut out latch slots per dwg D3186 (D3186-1 detail) ml07/08/07						
3.0	QC5 	INSPECT WORK TO CURRENT STEP 				
Comment: INSPECT WORK TO CURRENT STEP ml07/08/22						
4.0	PACKAGING 1 	PACKAGING RESOURCE #1 				
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: GA ml07/08/22						
5.0	QC21 	FINAL INSPECTION/W/O RELEASE 				
Comment: FINAL INSPECTION/W/O RELEASE D07/08/31						
Job Completion				a 07.08.31		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/08/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/08/08	2.0	0.171 hole pattern was drilled 1/8 instead of 1.30. Both hole patterns are off P.L. Human Error	QS1012	Send affected areas to fill holes with Hysol 4 milled fiber. Repair per QS137 Section 9.1.	ML 07/08/08	SP 07/08/08	QS1012	07/08/08
			QS1012	Prime affected area with Devcon + grey primer per QS1005 Section 4.2	ML 07/08/08	SP 07-08-22	QS1012	07-08-08
			QS1012	Use Hysol EA 9309 M103866 milled fiber M100859 4/R filled up 8 holes and let cure 24 hours and prime	ML 07/08/08	SP 07-08-22	QS1012	07-08-08
				After Prime and Paint				

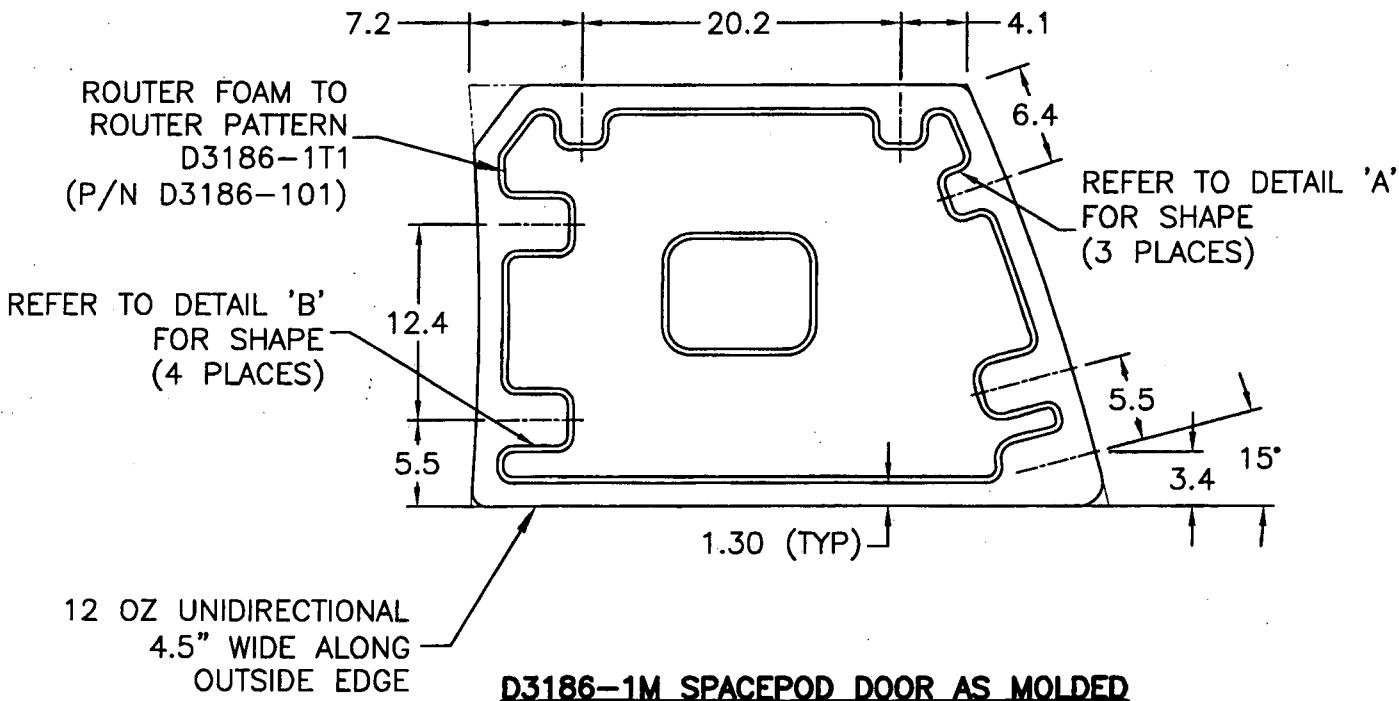
NOTE: Date & initial all entries

DART

DESIGN DS	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3186	REV. C SHEET 1 OF 5
DATE 06.12.13		TITLE SPACEPOD DOOR	SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
 9 OZ SATIN (9 SQ FEET)
 FOAM
 9 OZ SATIN (9 SQ FEET)
 12 OZ UNIDIRECTIONAL
 9 OZ SATIN (9 SQ FEET)
 RESIN (35-45% BY WEIGHT)
 PEEL PLY

NOTES:

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINCELL OR AIREX OR KLEGECCELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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06.12.22

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DATE 06.12.13		TITLE SPACEPOD DOOR

REV. C

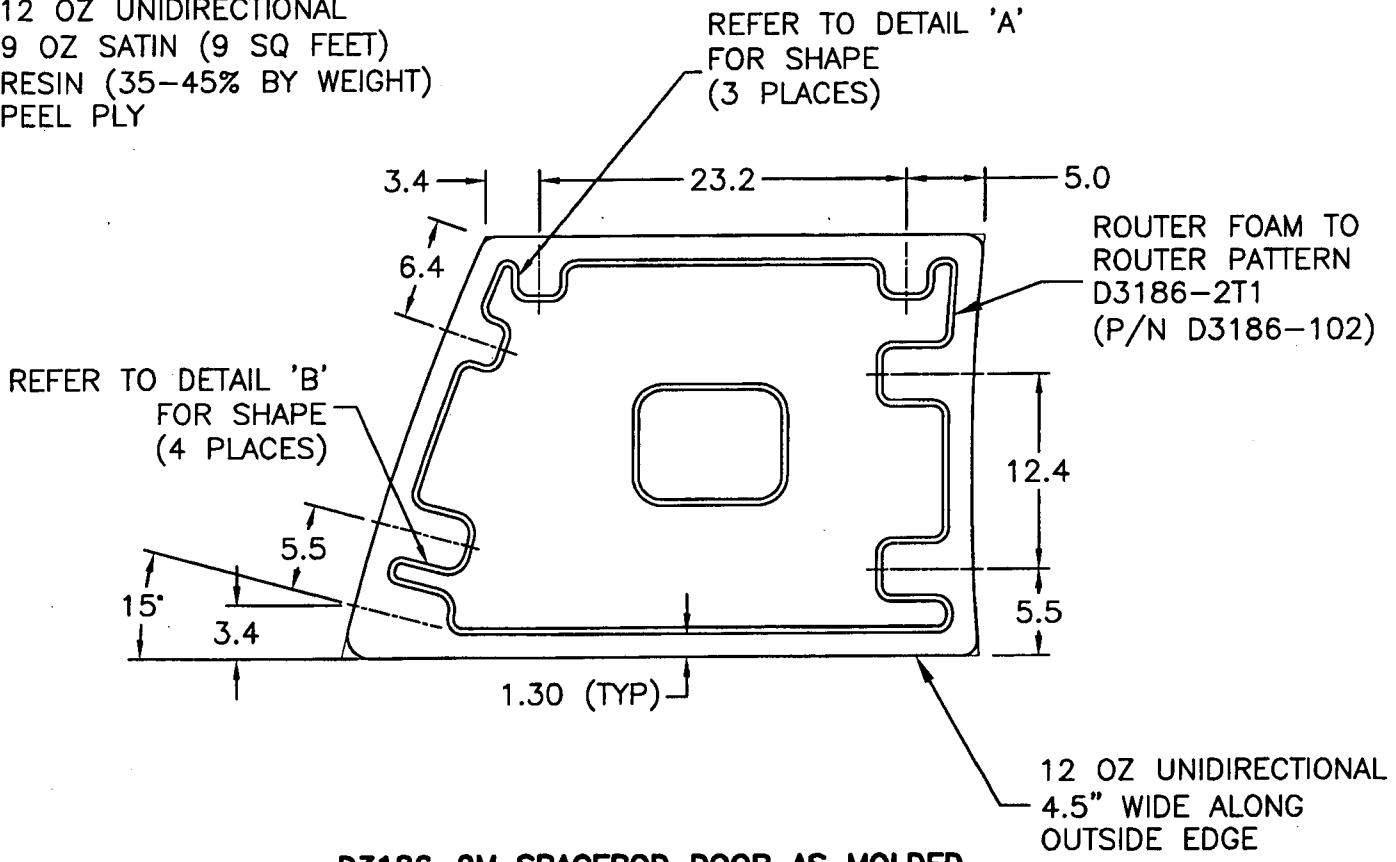
SHEET 2 OF 5

SCALE

NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
 9 OZ SATIN (9 SQ FEET)
 FOAM
 9 OZ SATIN (9 SQ FEET)
 12 OZ UNIDIRECTIONAL
 9 OZ SATIN (9 SQ FEET)
 RESIN (35-45% BY WEIGHT)
 PEEL PLY

RELEASED
06.12.13NOTES:

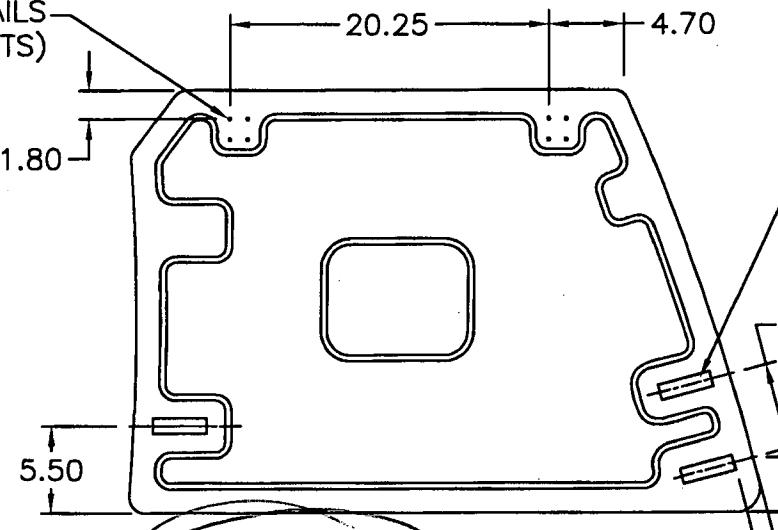
- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECCELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
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DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS

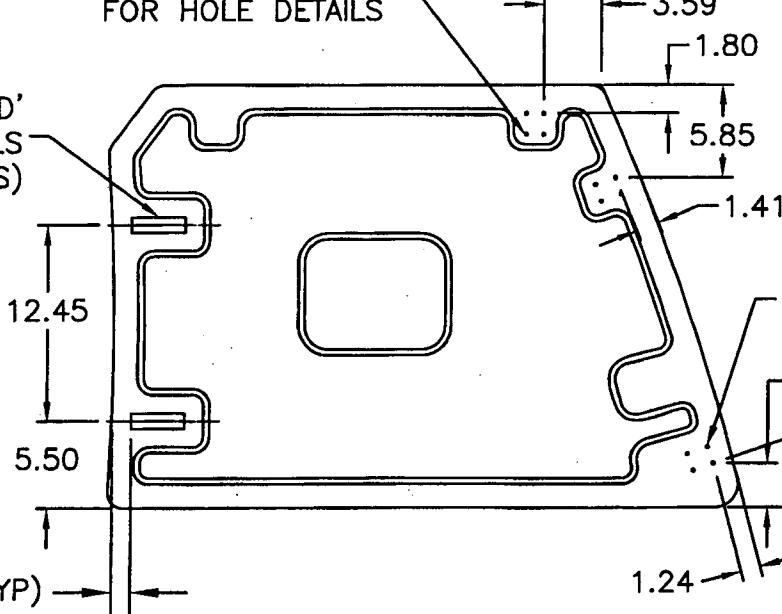
REFER TO DETAIL 'C'
FOR HOLE DETAILS
(2 SETS)



RELEASED
ai-222

REFER TO DETAIL 'D'
FOR CUTOUT DETAILS
(3 PLACES)

REFER TO DETAIL 'C'
FOR HOLE DETAILS



REFER TO DETAIL 'E'
FOR HOLE DETAILS
(2 SETS)

REFER TO DETAIL 'D'
FOR CUTOUT DETAILS
(2 PLACES)

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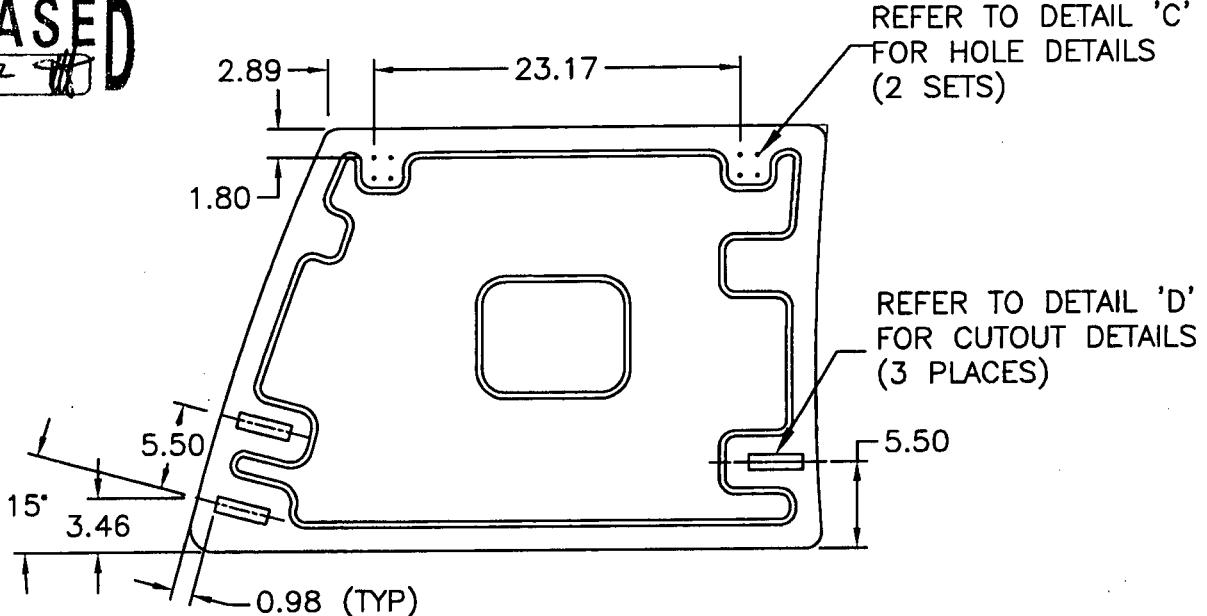
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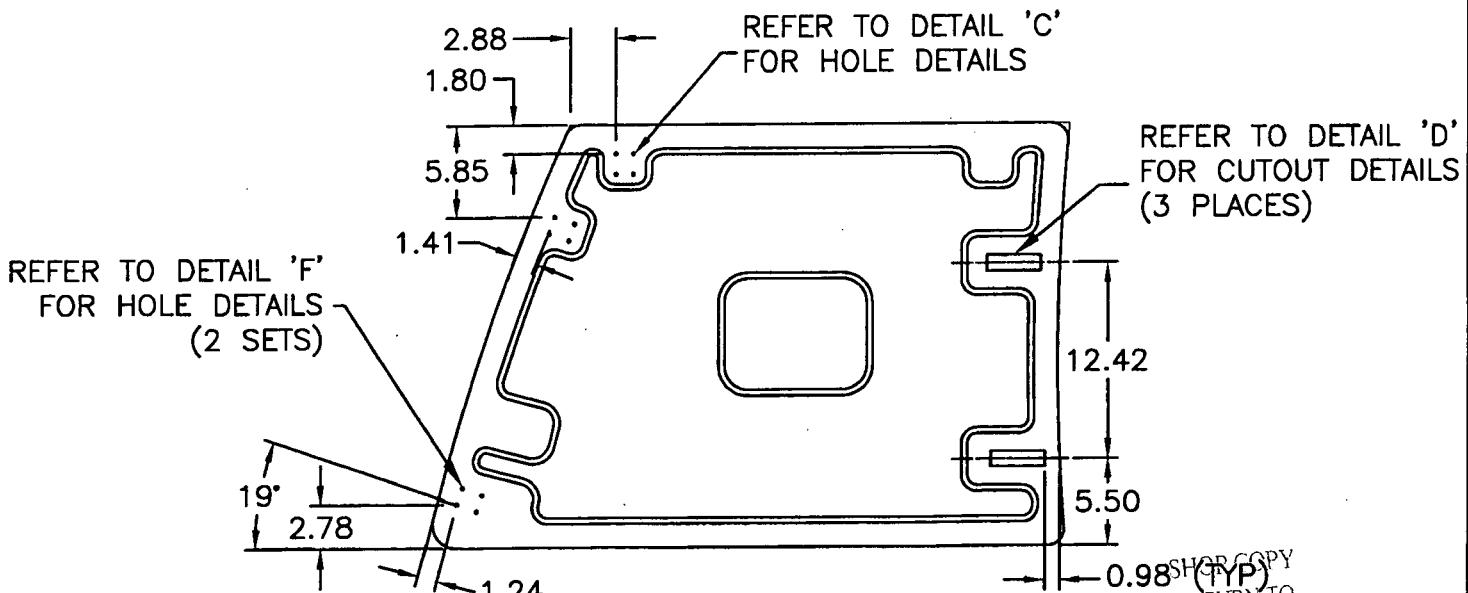
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DATE 06.12.13		TITLE SPACEPOD DOOR	SCALE NTS

RELEASED
06.12.22

D3186-2 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)

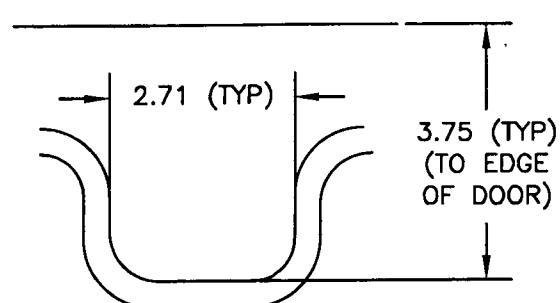
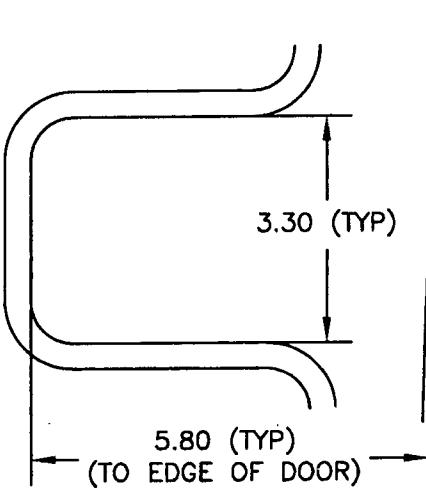
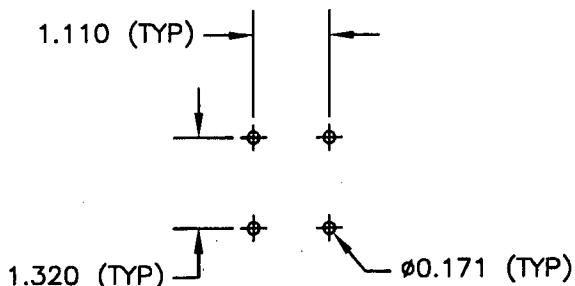
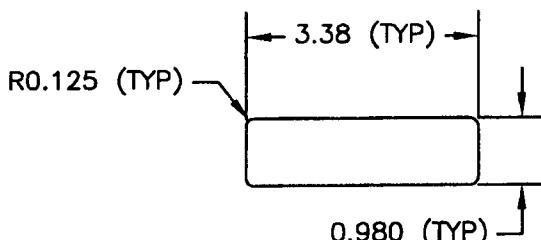
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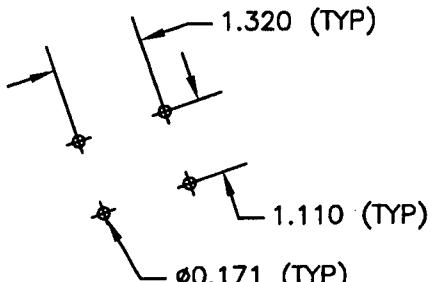
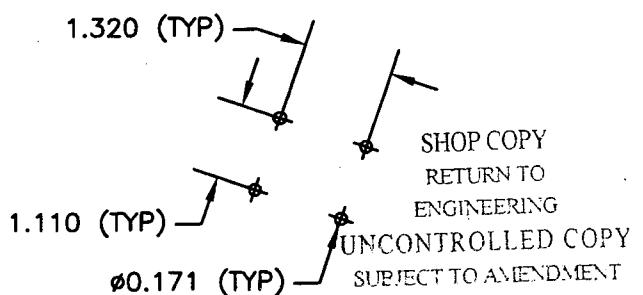
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CHECKED <i>PH</i>	APPROVED <i>CH</i>	DRAWING NO. D3186	REV. C SHEET 5 OF 5
DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS

**DETAIL A****DETAIL B****DETAIL C**

NOTE: ENSURE THAT CUTOUT IS
PERPENDICULAR TO EDGE OF DOOR

DETAIL D**DETAIL E**

WORK ORDER
31048C
06.12.22
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